

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018643**Date Inspected:** 10-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

Heat straightening of PCMK, 20TR-046 under approved Heat Straightening procedure, HSR (B)-363. The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhu Lin. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 80mm.

Bay 2

This QA Inspector observed the following work in progress for Bay 2.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhu Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Traveler Rail

PCMK: E5-SB1-041-026~031

Welder: 045276

WPS-B-T-2132-3

WELDING INSPECTION REPORT

(Continued Page 2 of 5)

PCMK: E5-SB10-001-026~031

Welder: 203871

WPS-B-T-2132-3

PCMK: E5-SB1-016-001~012

Welder: 045203

WPS-B-T-2133

PCMK: E5-SB1-003-020~021

Welder: 045240

WPS-B-T-2132-3

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhu Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam

PCMK: FB3266-001-074,075

Welder: 045271,217805

WPS-B-T-2132-3

Components: Bulk Head

PCMK: SA3325-001-054

Welder: 206623

WPS-B-T-2232-TC-U4b-F

PCMK: SA3324-001-016

Welder: 055564

WPS-B-T-2232-TC-U4b-F

Bay 4

This QA Inspector observed the following work in progress for Bay 4.

ZPMC was using the Submerged Arc Welding (SAW) process.

ZPMC QC is identified as Li Zhi Jiang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam

PCMK: SA3361-001-001

Welder: 050502

WPS-B-T-2221-B-L2C-S-2

WELDING INSPECTION REPORT

(Continued Page 3 of 5)

Components: Bulk Head
PCMK: SA3362-001-001
Welder: 207288
WPS-B-T-2221-B-L2C-S-2

Bay 6

This QA Inspector observed the following work in progress for Bay 6.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zheng Zhi Wei.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Cross Beam
PCMK: CB3003E-019-002
Welder: 062447
WPS-B-T-2231-B-U2-F

PCMK: CB3002A-018-027
Welder: 053742
WPS-B-T-2232-B-U5-F

Components: Floor Beam
PCMK: FB3168-002-039
Welder: 053609
WPS-B-T-2232-B-U3-F

PCMK: FB3168-002-044
Welder: 217185
WPS-B-T-2232-B-U3-F

This QA Inspector observed the following work in progress for Bay 6.
ZPMC was using the Submerged Arc Welding (SAW) process.
ZPMC QC is identified as Zheng Zhi Wei.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

PCMK: CB3003E-019-001
Welder: 215960
WPS-B-T-2221-B-L2C-S

Bay 7

This QA Inspector observed the following work in progress for Bay 7.
ZPMC was using the Shield Metal Arc Welding (SMAW) process.

WELDING INSPECTION REPORT

(Continued Page 4 of 5)

ZPMC QC is identified as Liu Chuan Gang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Cross Beam

PCMK: X4253C-001-001

Welder: 053753

Report: B-CWR2021

WPS-345-SMAW-1G (1F)-Repair

PCMK: X4253B-001-001

Welder: 048659

Report: B-CWR2032

WPS-345-SMAW-1G (1F)-Repair

PCMK: X4253B-002-001

Welder: 053795

Report: B-CWR2033

WPS-345-SMAW-1G (1F)-Repair

PCMK: CB3003B-019-005

Welder: 215689

WPS-B-T-2231-B-U2-F

Components: Barrier rail

PCMK: W2-SB1-022-57~62

Welder: 048625

WPS-B-T-2132-3

PCMK: W2-SB9-112,114

Welder: 051246

WPS-B-T-2132-3

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 5 of 5)



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
